

DART AEROSPACE LTD		Work Order:	21384
Description: Double Double Assy		Part Number:	D3151-041
Dwg: D3151-041		Qty:	6
Page 1 of 1			

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller	U	04-09-15	6
2	GA	cut blank mat'l			
		back m148805			
3	GA	make cut size D3151-1 D3151-3 as per Draw D3151	ml	04-09-13	6
4	GA	alodine	ml	04-09-13	6
5	GA	Make the Holes for rivets and - chairs nut plate touch up of alodine for each hole	ml	04-09-15	6
6	GA	install rivet MS 20426 AD3-3 QTY 6 - MS 20426 AD3-3 M7681 install nut plate			
		2 MS 21059 L08 M9032	ml	04-09-20	6
		4 MS 20426 AD3-4 M9748			
7	2C	INSPECT To step 6	ml	04-09-20	6
8	BT	Put in Stock	ml	04-09-20	6

Rev	Date	Change	Revised By	Approved
A		25.77 New issue		

10 DC Inspect Level 21
Close wlo

04.09.21 6

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Aug 23, 2004
09:51 am

Work Order No : 0021384
Project Name : D3151-041
Project For : WK440
Work Order Type : Main
Main WO Number :
House Part Number : D3151-041
Description : Doubler Assembly
Manufactured : No
Amount Req'd :
Amount Done :
Start Date : 08-23-04
Est Finish Date : 09-21-04
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

B 21384

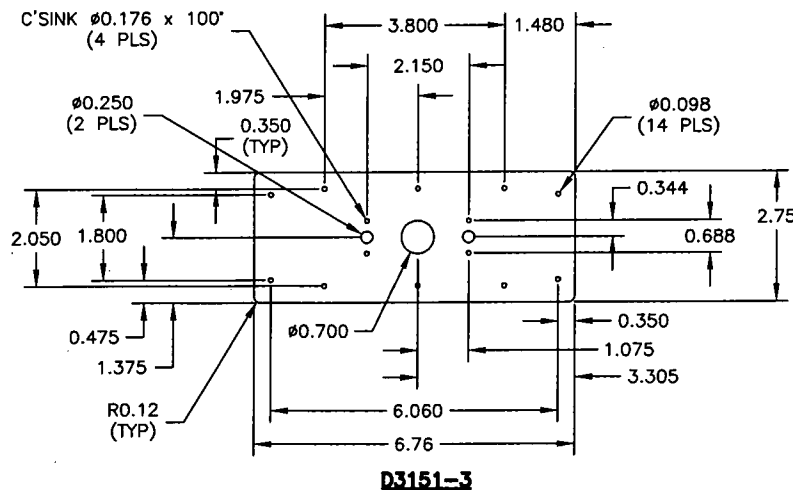
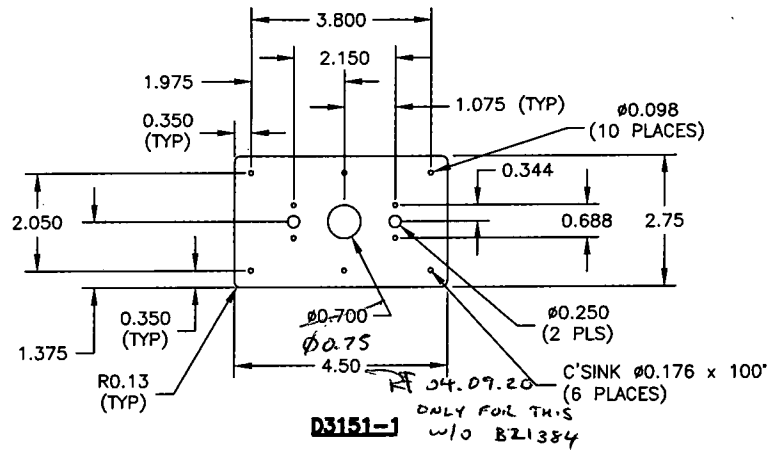
DESIGN <i>RT</i>	DRAWN BY <i>RT</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3151	REV. B SHEET 1 OF 1
DATE 04.09.08	TITLE DOUBLER ASSEMBLY		SCALE 1:4
A	02.04.23	NEW ISSUE	
B	04.09.08	RE-DESIGN	

MS20426AD3-3 RIVET (1)
(6 PLACES)

MS21059L08 NUTPLATE (1)
MS20426AD3-4 RIVET (2)
(2 PLACES)

D3151-1
D3151-3

D3151-041 DOUBLER ASSEMBLY
REPLACES PREMIER P/N B30-23000-173/-174



NOTES

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.040" THICK (REF. DART SPEC. M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N D3151-041 USING FINE POINT PERMANENT INK MARKER

PRELIMINARY ISSUE

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